

# Work Order ID 60339

July 6, 2010 7:30:54 AM



## PRELIMINARY ISSUE

Page 1

Item ID: D4102-3

Accept



Setup Start



Revision ID:

Item Name: SHIM

Stop



Start Date: 07/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 28/07/2010 Req'd Qty: 2.00



Customer:



Reference:

*Ref 10 07 09*

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4102

REV. PRELIM

*PAY*

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

*ent 10/07/09*

*2*

Jeaspa Bandsaw

4.950" long

110

0.00



HAAS 1

Memo

0.00

*2 10/02/15*

*2*

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA945

FOLIO REV: *AA*

DWG REV: *PAY*

DEBURR

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Page 2

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Start Date: 07/07/2010 Start Qty: 2.00



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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

□□

*SS 10/07/15*

*2*

*β*

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*~inspected to P44  
Dry only  
5/10/07/15 (2)*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*94 10/07/16*

*X2 0*

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July 6, 2010 7:30:54 AM



Page 3

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Setup Start



Revision ID:

Stop



Item Name: SHIM

Start Date: 07/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 28/07/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 inspects to 100% 0.00 Dry ok 8/10/15							
160  Packaging Packaging	Identify as per dwg & Stock Location: <i>Prod. Shelf.</i>  Memo	0.00 0.00							
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

*100% test  
10.07.22  
confirming  
10.07.30  
Rev A.*

*MF  
10-7-21*

# Picklist Print

Page 1

July 6, 2010 7:30:54 AM

Work Order ID: 60339



Parent Item: D4102-3



Parent Item Name: SHIM

Start Date: 07/07/2010

Required Date: 28/07/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-07-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.00 0		Purchased	No				f	16.5000	0.042	0.088421			



6061-T6 Bar .250 x 4.00

Location

Loc Qty

Loc Code

MAT

16.5

110680

0.5

114608

16

.088421 *ml*  
10/07/09

POSITIVE RECALL

EFFECTIVE 10-07-06 AUTH LL

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_





# Receiving Report

Date: 9/10/28

Batch No: M110650

Supplier: mlcwa

Part P/O: 8075

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☒ No ☐ N/A ☐  
 Shipping Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection: ☒ N/A ☐  
 Work Order: 020022 N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M62024735032		792	0	0	192	
M6061T6B250X460		60	0	0	60	
M6061T6706X460		108	0	0	108	

Initials of receiver (if shipment OK) Level 12 60

Production/Admin:

Date

Received/Costing

Initial

09/10/2023

RC #10 10/29

CX

Location

# Dart Aerospace Ltd

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613) 632-3336  
Fax: (613) 632-4443

## Receiving Slip

Date Feb 3, 2009	Page 1
Receipt Number RCP00010129	

### Purchase From:

Magna Stainless  
5775 rue Kieran  
St Laurent, Quebec H4S 0A3  
Canada

### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00008045

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M303R0750	303 Round Bar 0.750	124.0000	f	3.166666	392.67	Feb 03, 2009
		NOTE: AISI 304/316 NOT ACCEPTABLE MATERIAL: AISI 303 ROUND BAR B/N110680					
	M6061T6B0250X0	6061-T6 Bar .250 x 4.00	20.0000	f	2.650000	53.00	Feb 03, 2009 ✓
		PER AMS-QQ-A-200/8 OR AMS 4160 PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR B/N110680					
	M6061T6T1250W1	ALUM. RD TUBING 1.2	160.0000	f	1.150000	184.00	Feb 03, 2009 ✓
		AS ABOVE B/N110680					
	M6061T6T1500W1	6061T6 RD TUBE 1.50 X	60.0000	f	1.500000	90.00	Feb 03, 2009 ✓
		AS ABOVE B/N110680					
	M6061T6TS1000W	6061T6 SQ TUBE 1.00 x	140.0000	f	1.100000	154.00	Feb 03, 2009 ✓
		OR AMS 4160 **** FLAT SQUARE EDGE**** AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 SQUARE TUBING PER AMS-QQ-A-225/8 OR MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 B/N110680					
	M304TR0875W065	304 round tube .875 x .0	120.0000	f	8.750000	1,050.00	Feb 03, 2009 ✓
		MAETRIAL: AISI 304/316 SS SEAMLESS ROUND TUBING B/N110680					

### Comments:

PLEASE DO NOT SHIP ON THE 28TH & 29TH OF JANUARY





# Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

## PACKING LIST

I006166

Page: 1 of 1

SOLD TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET

HAWKESBURY, ON  
K6A 1K7  
Contact: CHANTAL

HAWKESBURY, ON  
K6A 1K7  
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

Currency		Sales Person		Customer Phone	Customer Fax	Customer PO		
CANADIAN DOLLARS		ERYCK BLAIS		(613) 632-5200	(613) 632-1053	8045		
Sales Order	Terms			Ship Via		Date Ordered	Date Required	Date Shipped
W006839	NET 30 DAYS			NIR:R-557065-1		01/23/09	01/28/09	01/28/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINUM FLATS AFL 6061 T6 1/4" x 4" x R/L ✓ 20' 24 LB / 1 PC	L006696	18836	1
7		PC	ALUMINUM SQUARE TUBE AST 6061 T6 SC 1" x .120" x R/L ✓ 20' 68 LB / 7 PC	L021366	5632	7
3		PC	ALUMINUM ROUND TUBE ATU 6061 T6 1.5" x .125" x R/L 20' 38 LB / 3 PC ✓	L015484	08050785A	3
8		PC	ATU 6061 T651 1.25" x .120" x R/L 20' 81 LB / 8 PC ✓	L021367	383 ✓ S.F. 09/01/30	8
10		PC	STAINLESS ROUNDS SRB 303 3/4" x R/L 12'4" 186 LB / 10 PC ✓	L020858	16486	10
Bundles: 3				Total Weight:		397 LB

Received by: \_\_\_\_\_

Date: \_\_\_\_\_

Signature: \_\_\_\_\_



# Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

## PACKING LIST

I006135

Page: 1 of 1

SOLD TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET

HAWKESBURY , ON  
K6A 1K7  
Contact:

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET

HAWKESBURY , ON  
K6A 1K7

Ship Terms: PREPAID

MTR:Y

### SPECIAL INSTRUCTIONS

DO NOT SHIP WILL ADVISE  
HOLD

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	CHANTAL 8045	
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W002587	NET 30 DAYS		TARGET	10/23/08	11/21/08	01/28/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
6		PC	316L SMLS 7/8" OD .065 X 20' 120.00 FT / 6 PC FUEL SURCHARGE 	L016423	YTO60922	6
Bundles: 1				Total Weight:	LB	

Received by: \_\_\_\_\_

Date: \_\_\_\_\_

Signature: \_\_\_\_\_

# DART

## Purchase Order

Date Jan 23, 2009	Page 1
Purchase Order Number PO00008045	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**FAXED**  
609/1/23

### Vendor Address:

Magna Stainless  
5775 rue Kieran  
St Laurent, Quebec H4S 0A3  
Canada  
Phone (514) 339-1211  
Fax (514) 339-1105

### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Jan 23, 2009	N30	yours	Jan 30, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
192.0000	M2024T3S032	2024-T3 .032 sheet Comments: MATERIAL: 2024-T3 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037	30/01/2009	No	3.645833	sf	700.00
✓ 120.0000 New 124	M303R0750	303 Round Bar 0.750 Comments: MATERIAL: AISI 303 ROUND BAR NOTE: AISI 304/316 NOT ACCEPTABLE	30/01/2009	No	3.166666	f	380.00
✓ 20.0000	M6061T6B0250X040	6061-T6 Bar .250 x 4.00 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 PER AMS-QQ-A-200/8 OR AMS 4160	30/01/2009	No	2.650000	f	53.00
60.0000	M6061T6B0250X060	6061-T6 Bar .250 x 6.00 Comments: AS ABOVE	30/01/2009	No	4.050000	f	243.00
108.0000	M6061T6T0625W065	6061-T6 RD Tube .625 x Comments: MATERIAL: 6061-T6 OR 6061-T62 TUBING PER VW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 ****SEAMLESS TUBING****	30/01/2009	No	4.770833	f	515.25
60.0000	M6061T6T1000W065	6061T6 RD TUBE 1.00 x Comments: AS ABOVE	30/01/2009	No	5.320833	f	319.25
✓ 160.0000	M6061T6T1250W125	ALUM. RD TUBING 1.250 Comments: AS ABOVE	30/01/2009	No 3	1.150000	f	184.00
✓ 60.0000	M6061T6T1500W125	6061T6 RD TUBE 1.50 X Comments: AS ABOVE	30/01/2009	No 4	1.500000	f	90.00
✓ 140.0000	M6061T6TS1000W12	6061T6 SQ TUBE 1.00 x Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62	30/01/2009	No 5	1.100000	f	154.00

12/9/01/08

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

12/11/06/30

Continued on next page...



# ANALYSIS CERTIFICATE

Empire Resources, Inc.

One Parker Plaza  
Fort Lee, NJ 07024-2937  
United States  
Tel : (201) 944-2200  
Fax : (201) 944-2226  
dfike@empireresources.com

EMPIRE Letter Ref # : EWR44185



Monday, 28 April, 2008

Date : April 28, 2008  
Sales Contract # : E131500  
Alloy-Temper : 6061-T6  
Container # : EXTR20080414  
Case # : EXC16740  
Cast # : 18836  
Die # : A10023  
Specification : .250" X 4" X 20' FLAT BAR 6061, T6  
Purchase Order : 073349-AD1  
Customer Part # :

S  
02/02/02

MADE IN THE USA

## Chemical Composition (WT%)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other Elements	
Min	0.40		0.15		0.8	0.04			Each Max	Total Max
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Actual	= 0.6	= 0.22	= 0.21	= 0.07	= 0.87	= 0.06	= 0.02	= 0.017	= 0	

\* Aluminum = Remainder

Actual cast analysis is retained on file.

## Tensile Properties

Test No.	Yield (ksi)	Tensile (ksi)	Elong. (%)
1	36.3	38.2	16.3

ASTM B221-06. AMS-QQ-A-200/8-97

C6755

*Ross Toombs*

Authorized Signature

Ross Toombs  
General Manager